

Work Order ID 139362-2

November 25, 2015 3:20:44 PM

139362

Page 1

Item ID: D205-633-011

Revision ID:

Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 11/25/2015 Start Qty: 4.00

Required Date: 12/11/2015 Req'd Qty: 4.00

Reference:

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

IIN-D205-633	C
--------------	---

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP205-633-011 CHG001

MIS 15-12-01

4

IX

DAS
27
9-89

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

NOV 30 2015

DAS
28
9-89

B138863 (X2)

B137610 (X1)

IX

DAS
27
9-89

DEC 01 2015

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : _____							

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Page 2

Item ID: D205-633-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Stop

NS2

Start Date: 11/25/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/11/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Packaging

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D205-633-011
Location:FG082

Sold

X/

*DAS
27
8-83*

DEC 09 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.01

Quality Control

MUS

DEC 10 2015

MUS

DEC 10 2015

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
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Root Cause		FAULT CATEGORY																							
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Picklist Print

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Work Order ID: 139362

139362

Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 11/25/2015

Required Date: 12/11/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:F02.07.11Reformat; Removed D3010 RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-14A		Purchased	No			110	Each	243.0000	1	4			

AN4-14A

Bolt

★★

DAS
28
3-89

Location Loc Qty Loc Code

FG 5

122141 5

ST325A 150

M133316 150

ST344 88

M129384 8

M133284 80

AN4-5A

Purchased

No

110

Each

136.0000

2

2/8

AN4-5A

BOLT

★★

DAS
28
3-89

Location Loc Qty Loc Code

CA 55

m129682 55

ST325A 50

m133064 50

ST345 31

120562 4

6651 1

m132317 26

DAS
27
3-89

DAS
27
3-89

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Work Order ID: 139362

139362

Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 11/25/2015

Required Date: 12/11/2015

Start Qty: 4.00

Required Qty: 4.00

AN4-6A Purchased No 110 Each 526.0000 2 8

AN4-6A

BOLT

Location

Loc Qty

Loc Code

CA 143
M128403 43
M130851 100
ST325A 100
M133363 100
ST345 283
M128403 8
M133316 275

DAS
28
9-89

AN4-7A Purchased No 110 Each 65.0000 2 8

AN4-7A

Bolt

Location

Loc Qty

Loc Code

ST325 65
m126193 2
m131320 63

DAS
28
9-89

AN5-14A Purchased No 110 Each 28.0000 1 4

AN5-14A

Bolt

Location

Loc Qty

Loc Code

ST299A 25
m132763 ✓ 25
ST338 3
m132823 3

DAS
28
9-89

NOV 30 2015

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Work Order ID: 139362

139362

Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 11/25/2015

Required Date: 12/11/2015

Start Qty: 4.00

Required Qty: 4.00

AN5-6A Purchased No

110 Each 14.0000 1 4

AN5-6A

Bolt

DAS
28
3-85
NOV 30 2015

Location Loc Qty Loc Code

ST286A 10

m133515 10

ST339 4

m131957 4

D2021-101 Manufactured No

110 Each 22.0000 1 4

D2021-101

Eyebolt

DAS
28
3-85

Location Loc Qty Loc Code

ST001 22

130984 22

D2022-101 Manufactured No

110 Each 129.0000 2 8

D2022-101

Spacer

DAS
28
3-85

Location Loc Qty Loc Code

ST001 39

107903 39

ST012a 90

132703 90

D2022-103 Manufactured No

110 Each 35.0000 2 8

D2022-103

Spacer

DAS
28
3-85
NOV 30 2015

Location Loc Qty Loc Code

ST001 19

123938 19

ST012a 16

134288 16

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Work Order ID: 139362

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Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 11/25/2015

Required Date: 12/11/2015

Start Qty: 4.00

Required Qty: 4.00

D2562-001

Manufactured No

110 Each

9.0000 1 4

D2562-001

Strut 19.68"

DAS

28

9-89

Location

Loc Qty

Loc Code

ST353

9

134240

1

138063

8

D2563

Manufactured No

110 Each

0.0000 1 4

D2563

Step Weldment Assembly

D2565-101

Manufactured No

110 Each

11.0000 1 4

D2565-101

Strut

B**138863 X2

B13760 X1

B**139361 X1

DAS

28

9-89

Location

Loc Qty

Loc Code

ST353

11

129688

3

131707

1

134294

1

137611

3

138868

3

D2565-103

Manufactured No

110 Each

11.0000 1 4

D2565-103

Strut

DAS

28

9-89

Location

Loc Qty

Loc Code

ST353

11

121437

1

131730

2

134308

2

137624

3

138885

3

DAS

28

9-89

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Work Order ID: 139362

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Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 11/25/2015

Required Date: 12/11/2015

Start Qty: 4.00

Required Qty: 4.00

D2565-105

Manufactured No

110

Each

11.0000

1

4

D2565-105

Strut

DAS

28

2-80

Location

Loc Qty

Loc Code

ST353

11

117052

3

134444

2

137711

3

138987

3

D2565-107

Manufactured No

110

Each

8.0000

1

4

D2565-107

Strut

DAS

28

2-80

Location

Loc Qty

Loc Code

ST354

8

130046

1

131128

1

136248

3

137782

3

D2565-109

Manufactured No

110

Each

11.0000

1

4

D2565-109

Strut

NOV 30 2015

Location

Loc Qty

Loc Code

ST354

11

131882

3

136192

2

137713

3

138988

3

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Work Order ID: 139362

139362

Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 11/25/2015

Required Date: 12/11/2015

Start Qty: 4.00

Required Qty: 4.00

D2565-111

Manufactured No

110

Each

12.0000

1

4

D2565-111

Strut

Location

Loc Qty

Loc Code

ST354

12

131027

1

134455

5

137719

3

138996

3

MS21042L4

Purchased

No

110

Each

1,482.000

8

32

MS21042L4

Locknut

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

57

m127813

57

ST260a

138

m130799

56

m131803

6

m132262

76

ST303

1116

m133363

1116

ST305

169

m128300

8

m130388

7

m130922

97

m132123

56

m133316

1

DAS 28 9-89

DAS 28 9-89

NOV 30 2015

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Work Order ID: 139362

139362

Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 11/25/2015

Required Date: 12/11/2015

Start Qty: 4.00

Required Qty: 4.00

MS21042L5

Purchased

No

110

Each

603.0000

2

8

MS21042L5

Nut

**

9.6
9.89
NOV. 27 2015

QAS
27
8-89

XY

Location

Loc Qty

Loc Code

CCK004

200

m133577

200

GA

146

m127813

146

ST303

9

m132677

9

ST304

200

m133363

200

ST305

48

m127813

19

m131340

21

m132123

8

QAS
28
8-89

Picklist Print

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Work Order ID: 139362

139362

Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 11/25/2015

Required Date: 12/11/2015

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0463J

Purchased

No

110

Each

3,992.000

15

60

NAS1149D0463.I

**

WASHER

Location

Loc Qty

Loc Code

GA

432

M129390

41

M132035

391

ST260a

1500

M133316

1500

ST263

618

M133284

618

ST269

1442

M129682

47

M130799

371

M132317

101

M132677

888

M133077

35

NOV 30 2015

DAS
28
3-89

Pieklis Print

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Work Order ID: 139362

139362

Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 11/25/2015

Required Date: 12/11/2015

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0563J

Purchased

No

110

Each

1,127.000

4

16

NAS1149D0563.J

**

Washer

Location

Loc Qty

Loc Code

GA

53

m125807

53

ST260a

128

m130799

63

m132035

55

m132256

10

ST263

747

m133134

247

m133363

500

ST269

180

m128257

156

m132677

24

ST271

19

m131026

19

X4

2.89

NOV 30 2015

NAS
28
2.89

16.4

5.0 PARTS LISTS

5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
1			1	D2021-101	EYEBOLT
2	2	2	2	D2022-101	SPACER
2	2	2	2	D2022-103	SPACER
1				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
	1			D2562-013	STRUT
1	1	1	1	D2563	WELDMENT ASSEMBLY
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
	1			D2565-201	STRUT
	1			D2565-203	STRUT
	1			D2565-205	STRUT
	1			D2565-207	STRUT
	1			D2565-209	STRUT
	1			D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	1	1		AN44-7A	EYEBOLT
2	1	1	2	AN4-5A	BOLT
2	3	3	2	AN4-6A	BOLT
2	2	2	2	AN4-7A	BOLT
1	1	1	1	AN4-14A	BOLT
	1	1		AN4-10A	BOLT
1			1	AN5-6A	BOLT
1	1	1	1	AN5-14A	BOLT
15	16	16	15	AN960JD416	WASHER
4	3	3	4	AN960JD516	WASHER
8	8	8	8	MS21042L4	NUT (or MS21042-4)
2	2	2	2	MS21042L5	NUT (or MS21042-5)

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Revision: C

Date: 13.12.13

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step™</i> , Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step™</i> , Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step™</i> , Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step™</i> , Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3276-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.